

Date: Wednesday, 2/15/2006 3:46:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 25833					
Estimate Number	: 10534					
P.O. Number	: N/A			Part Number	: D2574	
This Issue	: 2/15/2006		S.O. No. : N/A	Drawing Number	: D2574 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : MACHINED PARTS	Drawing Revision	: E	
Previous Run	: 25620			Material	: N/A	
Written By	: SEE COMMENT BELOW			Due Date	: 3/15/2006	
Checked & Approved By	: J.G. 06.02.16			Qty:	10	Um: Each
Comment	: Est Rev: 1 As Per Rev E 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B23940	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: 35833 Double check by: S.A.	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:15 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25833

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 06.03.04

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06.03.06 11

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-06

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11 06.03.06 11

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY80

C 206103107 11

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06103108 11

Job Completion



W 0603-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	25833
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.746	1.745	1.747		
C	3.495	3.505		3.497	3.497	3.496	3.497		
D	1.745	1.755		1.745	1.746	1.745	1.747		
E	7.990	8.010		8.004	8.004	8.005	8.006		
F	0.490	0.510		0.501	0.499	0.499	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.499	0.499	0.498		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.567	0.566	0.565		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.369		
N	2.495	2.505		2.496	2.496	2.497	2.497		
O	4.119	4.129		4.121	4.121	4.123	4.123		
P	0.115	0.135		0.123	0.123	0.121	0.123		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.248	0.250	0.251		
S	0.115	0.135		0.126	0.130	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.280	3.230	3.230	3.230		
V	0.230	0.250		0.237	0.237	0.242	0.241		
W	0.115	0.135		0.125	0.125	0.125	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.247	0.245		
AE	1.500	1.520		1.515	1.510	1.510	1.509		
AF	0.115	0.135		0.136	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.253	0.254	0.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	E.P	Audited by:	J.L
Date:	06/03/01	Date:	06.03.01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD				Work Order:	25833
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.749	1.749	1.749	1.748		
C	3.495	3.505		3.499	3.498	3.499	3.501		
D	1.745	1.755		1.749	1.749	1.749	1.748		
E	7.990	8.010		8.003	8.003	8.003	8.004		
F	0.490	0.510		0.500	0.499	0.501	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.502	0.500	0.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.567	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.369	1.368	1.369	1.369		
N	2.495	2.505		2.500	2.499	2.498	2.499		
O	4.119	4.129		4.124	4.123	4.122	4.122		
P	0.115	0.135		0.125	0.127	0.130	0.130		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.249	0.249	0.249		
S	0.115	0.135		0.125	0.124	0.128	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.221	3.221	3.221		
V	0.230	0.250		0.240	0.244	0.241	0.242		
W	0.115	0.135		0.127	0.129	0.128	0.131		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.631	0.632	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.254	0.254	0.255		
AE	1.500	1.520		1.508	1.509	1.508	1.509		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.267	0.269		
AH	0.240	0.260		0.251	0.247	0.248	0.248		
AI	2.000	2.020		w/1	w/1	w/1	w/1		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	J.G	Audited by:	J.L
Date:	06/03/02	Date:	06.03.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD				Work Order:	25833
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

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B	1.745	1.755		1.747	1.746	1.747			
C	3.495	3.505		3.499	3.496	3.496			
D	1.745	1.755		1.747	1.746	1.747			
E	7.990	8.010		8.004	8.004	8.004			
F	0.490	0.510		0.500	0.496	0.498			
G	0.257	0.262	DT8683	0.257	0.257	0.257			
H	0.375	0.380	DT8684	0.375	0.375	0.375			
I	0.490	0.510		0.499	0.502	0.500			
J	1.174	1.184		1.177	1.177	1.179			
K	0.558	0.578		0.568	0.567	0.568			
L	1.174	1.184		1.177	1.177	1.179			
M	1.365	1.375		1.370	1.368	1.369			
N	2.495	2.505		2.499	2.502	2.502			
O	4.119	4.129		4.122	4.121	4.123			
P	0.115	0.135		0.130	0.123	0.124			
Q	0.115	0.135		0.130	0.130	0.130			
R	0.240	0.260		0.249	0.254	0.252			
S	0.115	0.135		0.120	0.129	0.131			
T	0.178	0.198		0.188	0.188	0.188			
U	3.210	3.250		3.224	3.230	3.230			
V	0.230	0.250		0.240	0.237	0.241			
W	0.115	0.135		0.127	0.126	0.130			
X	0.307	0.312		0.310	0.310	0.310			
Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.360	0.360	0.360			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.629	0.625	0.626			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.249	0.250	0.250			
AE	1.500	1.520		1.512	1.509	1.509			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.244	0.260	0.260			
AH	0.240	0.260		0.250	0.252	0.252			
AI	2.000	2.020		w/4	w/4	w/4			
AJ	0.023	0.043		0.030	0.030	0.030			

Accept/Reject

Measured by:	SG/	EP	Audited by:	JL
Date:	06/03/03	06/03/04	Date:	06.03.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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